

SPLIT

Date: Thursday, 6/7/2007 3:30:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP EXTRUSION
Job Number	: 32858		
Estimate Number	: 10058		
P.O. Number	: N/A	Part Number	: D2622120C
This Issue	: 6/7/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2622 REV C1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31984	Drawing Revision	: C1
		Material	: N/A
Written By	: [Signature]	Due Date	: 6/30/2007
Checked & Approved By	: [Signature]	Qty:	: 118
Comment	: Est A 02.11.12 New Issue KJ/RF	Unit:	: Each

Additional Product

Job Number: [Barcode]

Seq. #	Machine Or Operation:	Description:
10	PO	PURCHASING

[Barcode] [Barcode]

Comment: PURCHASING

Issue P/O: 3937

a) Extrude as per Dwg D2622 Rev. C

b) Material: 6061-T6 (QQ-A-200/8)

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 38 ksi

e) Minimum elongation = 8%

f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A

h) To be packed per DSK 066

i) Pull test to ASTM standard B221 required.

j) Material certification is required

[Signature] (131)

20	D2622120CP	Extrusion
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[Barcode] [Barcode]

Comment: Qty: 1.0000 Each(s)/Unit Total: 110.0000 Each(s)

Extrusion

30	PACKAGING 1	PACKAGING RESOURCE #1
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[Barcode] [Barcode]

Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

[Signature] (132)

40	QCE	DIMENSIONAL CHECK
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[Barcode] [Barcode]

Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622

Check Pull test per Dwg D2622 for compliance page attached

Check hardness with Webster tester

[Signature] 72+60 (132)

63

Date: Thursday, 6/1/2007 3:30:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 32858

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WH

P.E. ~~07.08.23~~ 60

5.0

QC21

FINAL INSPECTION/W/O RELEASE



(60)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/04

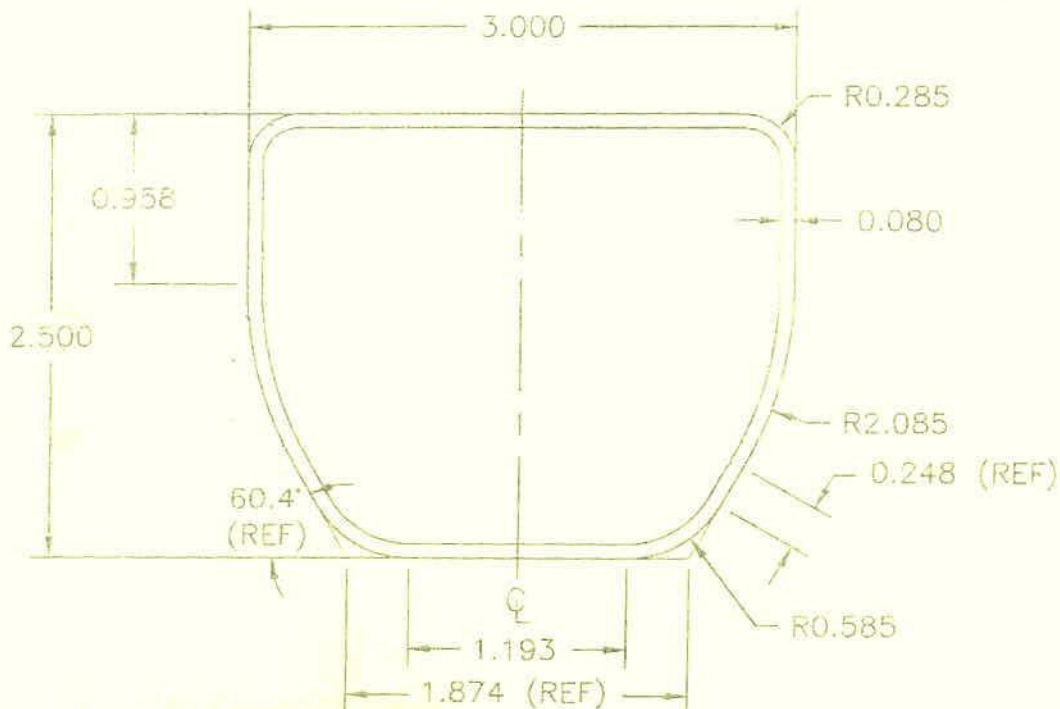
Job Completion



1 07.08.24



DESIGN	KE	DRAWN BY	GP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. C
				D2622	SHEET 1 OF 1
DATE			TITLE	SCALE	
02.09.11			STEP EXTRUSION	1:	
A		96.11.29	NEW ISSUE		
B		97.12.12	CHANGE MATERIAL, ADD TOL. CSI		
C		02.09.11	0.080 WAS 0.085; ADD PART & DIE NO.		
CI	#	GP	02.10.04	ADD 'REV A' TO DIE NUMBER	



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

32850

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BON L CANADA INC.

THE WILLIAM L. BONNELL COMPANY, INC.
BON L MANUFACTURING COMPANY
SUBSIDIARIES OF TRELEGAR CORPORATION
FILIALES DE LA CORPORATION TRELEGAR



INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION

BON L CANADA INC
504 EDWARD AVENUE
RICHMOND HILL ON

LOT 970

SHIPPING MANIFEST
BORDEREAU D'EXPEDITION

MANIFEST DATE/DATE D'EXPEDITION

MANIFEST NUMBER/N° D'EXPEDITION

SALES ORDER NUMBER/N° DE COMM.

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE
REFEREZ-VOUS A CES
NUMEROS POUR TOUTE
CORRESPONDANCE.

SHIP TO/EXPEDIE A

SOLD TO/VENDU A

ART AEROSPACE LTD.
270 ABERDEEN ST
AWKESBURY
6A 1K7

ART AEROSPACE LTD
1370 ABERDEEN ST.
HAWKESBURY
K6A 1K7

ON
ON

ON
ON

CREDIT REP.

REP DU CREDIT

HAMBROOK, PAU
905-508-3250

SALES REP.

REP DES VENTES

FIELD SALES REP

REP REGIONAL DES VENTES

Kutter A

450-435-6581

CUST SERVICE REP

REP SERVICE CLIENTELE

Burton D

905-427-2227

PHONE 613-632-5200

PHONE 613-632-5200

STOMER ID/N° DU CLIENT

ORDER DATE

CUST. PO. TO W/CE COMM. DU CLIENT

JOB/PROJET

LIH

57 194

60000

BILL OF LADING NUMBER/N° DE CONNEMENT

46024

06/08/97

3937

00349568

ITEM VO. ITEM	ORDER QUANTITY QTE COMMANDEE	UNIT UNITE	PREVIOUS SHIPPED QTY. QTE DEJA EXPEDIEE	MFG. PART NUMBER N° DE PIECE DU FOURNISSEUR	CUTTING TOLERANCE TOLERANCE DE COUPE	FINISH DESCRIPTION DESC. DE LA FINITION	THIS SHIPMENT/CETTE EXPEDITION			UNIT UNITE	QUANTITY DU QUANTITE PRE
							NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
01		KG		0 DAA-997133-1	6061 / TO	MILL	2	575	554	KG	
		M		0 D2622	123"	CERTIFICATE OF COM			402.34	M	
	121	PC		0	123/12 "	123/12-015.0139-1101			132	PC	
Actual is 132											
DETAIL: LOT/TICKET											
				04203010 / 173427			1	313	302		72 P
				04204010 / 173428			1	262	252		60 P

132

CRM NO. B1065 REV. C

TO RETURN MATERIALS, SEE ACCEPTANCE OF RETURN MATERIALS

POUR RETOUR DE MATERIEL, VOIR ACCEPTATION DE RETOUR DE MATERIEL

CUSTOMER
CLIENT

**BON L CANADA INC**500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No	Sales Order	Page
07/06/07	162381	74203	1
Cust PO	R/I No	Lot	Date
3937	00349565	74203010	7/06/07

Sold To	48024	Ship To	48024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	575 KGS		
Net Qty	554 KG	132 PC	402 M 2 PKG
Specification	AMS-QQ-A-200/8 & ASTM B221-00		
		Qlt Desc	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	291.8 / 42.3	251.8 / 36.5	10.2	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.62	.26	.24	.01	.86	.05	.011	.07	.000	.006	.01	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBake1, QA Manager Signed for Bon L Canada

